

Work Order ID 145261

Thursday, May 05, 2016 9:25:07 AM

145261

Page 1

Item ID: D6023-106 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Crosstube Material
Start Date: 5/6/2016 Start Qty: 23.00 *23* Cust Item ID:
Required Date: 5/20/2016 Req'd Qty: 23.00 *23* Customer:
Reference:

Approvals: Process Plan: MLS Date: MAY 05 2016 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D6023	A

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O

a) Extrude as per Dwg D6023
b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11)
seamless aluminum tube

c) Minimum ultimate tensile strength = 77 ksi

d) Minimum tensile yield strength = 66 ksi

e) Material certification is required

***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE
SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH
AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS,
OR DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

23 MAY 06 2016 DAS 13 9-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 145261

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Page 2

Item ID: D6023-106**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Crosstube Material**Start Date:** 5/6/2016 **Start Qty:** 23.00***23*****Cust Item ID:****Required Date:** 5/20/2016 **Req'd Qty:** 23.00***23*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.46							
Packaging	Ensure material certification is attached								
120	QC18 In-Coming Inspection Material	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6023								
140	Identify as per dwg & Stock Location: LG003	0.00							
140									
Packaging	Memo	0.23							
Packaging	LOCATION : LG003								

26v 50 16-8-30

(26) 16-04-01 P1

26 16/9/7 UHJ

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Work Order ID 145261

Thursday, May 05, 2016 9:25:07 AM

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Page 3

Item ID: D6023-106

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Material

Start Date: 5/6/2016 Start Qty: 23.00

23

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 23.00

23

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

2.30

Quality Control

DAS
21
9-89

SEP 07 2016

DAS
21
9-89

SEP 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause		FAULT CATEGORY	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐			

Thursday, May 05, 2016 9:25:10 AM

145261

D6023-106

Start Date: 5/6/2016

Required Date: 5/20/2016

Start Qty: 23.00

Required Qty: 23.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

Purchased

No

Each

0.0000

23

D6023-106P

26x 8p/b-f-30

Crosstube Material

DQA: _____ Date: _____



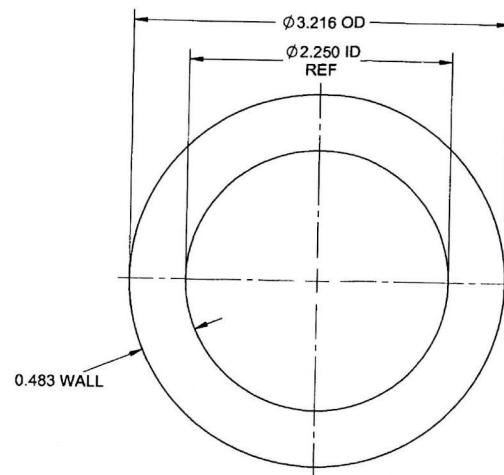
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

SPECIFICATION CONTROL DRAWING



D6023-XXX CROSSTUBE MATERIAL

WHERE XXX IS LENGTH IN INCHES.
EG. 106" LONG TUBE: D6023-106

NOTES:

1) MATERIAL: 3.216 OD X 0.483 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 KSI
MINIMUM YIELD TENSILE STRENGTH = 66KSI

2) FINISH: NONE

3) TOLERANCES: PER ASTM B210 AS FOLLOWS:

O.D.: +/- 0.008 MEAN (+/- 0.016 INCLUDING OVALITY)
WALL: +/- 0.021 MEAN (+/- 0.048 INCLUDING ECCENTRICITY)
LENGTH: XXX +0.188/-0.000
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 145261 MJS
1605-05

RELEASED
2015-11-04
EN 15-692

APPROVED

A		NEW ISSUE		AP	15.10.13
REV.	DESCRIPTION			BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AP				
CHECKED	AJS	DRAWING NO. D6023			REV. A
MFG. APPR.	JLM	TITLE CROSSTUBE MATERIAL			SHEET 1 OF 1
APPROVED	WM				SCALE
DE APPR.	DS				NTS
DATE	15.10.13	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32286

Purchase Order Date 5/6/2016
PO Print Date 5/6/2016

Page Number 1 of 2

Order From :

KAISER ALUMINUM
6573 W WILLIS ROAD

CHANDLER, ARIZONA 85226
USA

VU-KAI001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
MAY 06 2016

Contact Name

Vendor Phone 520 796 1097 Ext.1020

Ship To Contact

Ship To Phone

Ship Via: —

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D6023-106P ✓ EXTRUDE AS PER DWG D6023-106 REV. A B145261	Crosstube Material	7/14/2016 Yes 7/14/2016		23.00 Each	\$562.96	\$12,948.08
						Line Total:	\$12,948.08
2	71401-45	PROCUREMENT QUALITY CLAUSES	7/14/2016 No 7/14/2016		1.00	\$0.00	\$0.00
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents							

Note:

5/6/2016

08/18/16

KAISER ALUMINUM FABRICATED PRODUCTS, LLC
PACKING LIST

PAGE 1

KAISER ALUMINUM
6573 W. WILLIS ROAD
BOX 5011
CHANDLER AZ 85226

SOLD TO

DART AEROSPACE LTD
HAWKESBURY ON K6A 1K7

INSIDE SALES REP

FACIO

DART AEROSPACE LTD
1270 ABERDEEN
STREETBILL OF LADING
SHIP DATE
CARRIER
LOAD NUMBER
TOTAL GROSS WT222648
08/18/16 SHIPMENT NBR- 220687 0001
CUSTOMER PICKUP
JU49
1179 LBS.

HAWKESBURY ON K6A 1K7

SHIP ITEM	RELEASE	ITEM	DESCRIPTION	P.O. NUMBER	LOT NUMBER	PACKAGE NUMBER	PACK PIECES	GROSS WGT	NET WGT	BACK FOOTAGE ORDER	INHOUSE DATE
1	220687	001	SPIRIT-391341 YOUR PART#: <u>D6023-106P</u> 51821 5.0262#/FT 4000 7075 T6511 106 IN +.1880 -.0000 TOL 7075 T6511 3.216" OD X 0.483" WALL HA EST	COMPLETE 32286	*51821-001 Dash 0001	M000126713	26 26	1179	1154	229.67	07/14/16
				TOTAL:			26	1179	1154	229.66	
						TOTAL NET WT		1154	FOOTAGE	229.66	

8/16-8-30

* MATERIAL CERTIFICATION REQUIRED FOR THIS LOT NUMBER.

KAISER ALUMINUM

ORDER ACKNOWLEDGEMENT

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

PURCHASE ORDER NO. 32286

OUR JOB NUMBER 1266942 (220687)

DATE 05/11/16

8322 01 01

S DART AEROSPACE LTD
O 1270 ABERDEEN
L STREET
D HAWKESBURY
T CANADA

ON K6A 1K7

S DART AEROSPACE LTD
H 1270 ABERDEEN
I STREET
P HAWKESBURY
T CANADA

ON K6A 1K7

CHANTAL LAVOIE

OUTSIDE SALES		INSIDE SALES		SHIPPING TERMS		CHANTAL LAVOIE		TERMS OF SALE	
ODOM		FACIO		PREPAY		NET 30 DAYS			
ITEM	DESCRIPTION	ESTIMATED SHIP WEEK		UM	ORDER QTY	QTY TOL %	UM	UNIT PRICE	

**For order status, product information and certification					**				
**reprints, register and visit us regularly at -					**				
**http://online.kaiseraluminum.com					**				

001	SPIRIT-391341			PC	23	15%	PC	562.964	
YOUR PART#: D6023-106P									
SHIP: 07/04/16 DELIVERY: 07/14/16									
51821 5.0262#/FT 4000 (3184)									
7075 T6511 44.39 +1/2-0									
106 IN +.1880 -.0000 TOL									
7075 T6511 3.216" OD X 0.483" WALL									
HA EST									
ACTUAL CHEMISTRIES REQUIRED WITH THIS ITEM									
OD/WALL TOLERANCE ARE INDIVIDUAL READINGS.									
NSP 026 - 3rd Party STRETCHING.									
TAG WITH PN D6023-106P									
DO NOT STENCIL and DO NOT OIL.									
CERTIFY TO SPEC: AMS-QQ-A-200/11.									
Also conforms to QQ-A-200/11.									
Ovality: +/- .016" Individual									
Eccentricity: +/- .048" Individual.									
ATTN PACKING: CARDBOARD WRAPAROUND THE BUNDLE.									
ATTN SHIPPING: When Material is Ready for Pick-UP									
Contact Chantal Lavoie at 613-632-9577 or									
E-Mail at: clavoie@dartaero.com									
When Material is Ready for Pick-UP									
AMS-QQ-A-200/11									
Also conforms to QQ-A-200/11									
Exterior Packing: MTL STRAP BARE BN, >1000#									
Battens Packing: ALL 4 SIDES									

CONTINUED

Acceptance of your order is subject to approval of our general sales office and, if not approved, you will be notified within 10 days of the date hereof. If such notice is not received within that time, and if you have not notified us of any error, it will be conclusively presumed that this acknowledgement correctly states the entire agreement between us. The Terms and Conditions of Sale printed on the attached or reverse side hereof are part of this acknowledgement.

KAISER ALUMINUM

ORDER ACKNOWLEDGEMENT

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

PURCHASE ORDER NO. 32286

OUR JOB NUMBER 1266942 (220687)

DATE 05/11/16

8322 01 01

S DART AEROSPACE LTD
O 1270 ABERDEEN
L STREET
D HAWKESBURY ON K6A 1K7
T CANADA
O

S DART AEROSPACE LTD
H 1270 ABERDEEN
I STREET
P HAWKESBURY ON K6A 1K7
T CANADA
O

CHANTAL LAVOTE

OUTSIDE SALES			INSIDE SALES			SHIPPING TERMS			TERMS OF SALE		
ODOM			FACIO			PREPAY			NET 30 DAYS		
ITEM	DESCRIPTION		ESTIMATED SHIP WEEK			UM	ORDER QTY	QTY TOL %	UM	UNIT PRICE	

The order reflected on this acknowledgement will be subject to Price in Effect at the time of shipment. An energy surcharge has been applied to each pound of product listed on this Order Acknowledgement & is included in the Price in Effect. Additional information with respect to the surcharge is available for your review on the Kaiser Aluminum website at: www.KaiserAluminum.com

Acceptance of your order is subject to approval of our general sales office and, if not approved, you will be notified within 10 days of the date hereof. If such notice is not received within that time, and if you have not notified us of any error, it will be conclusively presumed that this acknowledgement correctly states the entire agreement between us. The Terms and Conditions of Sale printed on the attached or reverse side hereof are part of this acknowledgement.

GENERAL TERMS AND CONDITIONS OF SALE ("TERMS")

A. AGREEMENT 1. These Terms and the provisions on the face hereof or agreement to which these Terms are attached shall constitute the entire agreement ("Agreement") between BUYER and SELLER as to the sale of these goods, and shall supersede all prior oral or written agreements and can be modified or canceled only by an agreement in writing. In case of any inconsistency between these Terms and other provisions of the Agreement, such other provisions shall prevail. BUYER expressly WAIVES all provisions contained in any of BUYER's correspondence or forms involved in this sale which negate, limit, extend or conflict with the Agreement. 2. BUYER agrees that it has not been induced to enter into this Agreement by any oral or written representation, guaranty or warranty made by SELLER, its employees, agents or representatives other than as expressly set out in this Agreement.

B. PRICE, TERMS OF PAYMENT, TRANSPORTATION, WEIGHT, TOLERANCES, OVERSHIPMENT, ALLOWANCES, AND TAXES. 1. SELLER's published prices, terms of payment, including discounts, and transportation terms in effect at DATE OF SHIPMENT of goods, shall apply unless (a) expressly provided otherwise in SELLER's price sheets in effect at DATE OF THE ACKNOWLEDGMENT, or (b) expressly provided otherwise in this Agreement. 2. Weights and volumes shall be determined by reference to bills of lading. 3. All deliveries are subject to the tolerances and overshipment allowances, if any, shown in SELLER's published price and/or data sheets in effect at the DATE OF ACKNOWLEDGMENT. 4. BUYER shall pay all sales, use, delivery, port, excise and other taxes, duties, or charges presently or hereafter payable in respect to this transaction, or if paid by SELLER for the account of the BUYER, BUYER agrees to reimburse the SELLER on demand.

C. PAYMENT 1. SELLER shall have the continuing right to approve BUYER's credit, and may at any time demand advance payment, satisfactory security or a guarantee of prompt payment. 2. If SELLER directs BUYER to remit payment to bank or other depository, BUYER agrees that such payment shall not necessarily constitute payment in full or a final settlement of BUYER's account notwithstanding any language to the contrary on BUYER's check, draft, or other order. 3. A service charge will be imposed on overdue amounts. BUYER agrees to pay SELLER's costs of collection of overdue invoices including, but not limited to attorney's fees.

D. WARRANTY 1. SELLER warrants that goods sold hereunder are merchantable UNLESS manufactured in conformance with BUYER's specifications, and that SELLER conveys good title thereto, although SELLER shall retain and is hereby granted by BUYER, a security interest in the goods sold until the purchase price is paid. BUYER further agrees to execute any other documents to perfect said security interest at the request of SELLER.

2. SELLER MAKES NO WARRANTY OF FITNESS FOR BUYER'S PARTICULAR USE OR PURPOSE, NOR ANY OTHER WARRANTIES, EXPRESS OR IMPLIED. SELLER EXPRESSLY DISCLAIMS ALL ORAL WARRANTIES. 3. SELLER SPECIFICALLY, BUT NOT BY WAY OF LIMITATION, DOES NOT WARRANT THE ACCURACY OR SUFFICIENCY OF ANY ADVICE OR RECOMMENDATIONS GIVEN TO BUYER IN CONNECTION WITH THE SALE OF GOODS HEREUNDER.

E. DEFAULT a. OF BUYER 1. BUYER shall be liable for SELLER's damages caused by BUYER's default hereunder. 2. If any amount is overdue or BUYER otherwise breaches this Agreement, or if BUYER's financial responsibility becomes impaired, or BUYER refuses to give any payment, security, or guarantee demanded, SELLER may terminate this Agreement and/or refuse to deliver any undelivered goods and BUYER shall immediately become liable to SELLER for the unpaid price of all goods delivered and for damages. b. OF SELLER 1. In the event of a breach of warranty by SELLER, SELLER at its option shall either (i) replace or repair the goods, (ii) refund the purchase price upon return of the goods, or (iii) grant a reasonable allowance on account of such breach. BUYER shall not return any goods until SELLER has had reasonable opportunity to investigate the claim and then only upon receipt of SELLER's written shipping instructions. THIS SHALL BE BUYER'S EXCLUSIVE REMEDY. 2. BUYER waives all claims arising from breach of warranty or any other breach of this Agreement by SELLER unless SELLER receives written notice of breach within thirty (30) days after delivery of the goods.

C. Neither SELLER nor BUYER shall be liable for any special, incidental, consequential contingent, negligent or punitive damages resulting from breach of warranty, delay of performance, or any other default hereunder.

F. TITLE AND RISK OF LOSS Title, risk of loss or damage, and other incidents of ownership shall pass to BUYER upon due tender of goods for delivery at the f.o.b. point, subject to SELLER's security interest.

G. FORCE MAJEURE 1. Neither BUYER nor SELLER shall be liable for any damages resulting from any delay or failure of performance arising from any cause not reasonably within such party's control including, but not limited

to the following:

Acts of God; fire, earthquake, hurricane, or other windstorm; labor disputes, whether or not the demands of labor are within the ability of the party to meet; embargoes; unavailability or shortage of power, labor, transportation, raw materials, or usual means of supply; shortage or curtailment of energy sources; wars; rebellions; civil disorders; regulations or acts of government; government agencies or instrumentalities; or any other cause whether similar or dissimilar to the foregoing.

The party affected by the force majeure shall give prompt notice thereof to the other. 2. In the event of force majeure, the time for performance under this Agreement (except BUYER's obligation to pay to SELLER money due) shall be extended for any period reasonably necessary due to such occurrence, during which this Agreement shall remain in full force and effect; provided, however, that SELLER may terminate this Agreement at any time during such extension period. SELLER shall have the right to allocate its available goods among its own uses and its customers, including those not under contract, in such manner as SELLER may deem fit. SELLER shall have no obligation to purchase substitute goods or transportation in order to complete delivery to BUYER; and if SELLER contemplated a specific source of supply, manufacture, or transportation, whether or not specified in this Agreement, SELLER shall not have any obligation to deliver goods to BUYER from or by any other source.

H. EQUIPMENT 1. Any equipment (including jigs, molds, dies and tools) manufactured or acquired specially to produce goods for BUYER shall be SELLER's property and remain in SELLER's possession, even though BUYER is charged therefor. 2. If BUYER for three(3) years does not order goods produced with such equipment, SELLER may dispose of it for SELLER's account, and SELLER shall not be required to replace it. 3. All items (such as reels, drums, and cores) specified as returnable shall be returned as provided in the price sheets in effect at DATE OF SHIPMENT, and credit for deposits shall be made as set forth therein.

I. PATENTS 1. SELLER shall defend and hold BUYER harmless from any claim made against BUYER's use or resale of goods normally offered for sale by SELLER while in the form, state, or condition, supplied by SELLER to BUYER constitutes infringement of any United States patent, provided BUYER promptly notifies SELLER in writing of the claim and BUYER gives SELLER full authority, information, and assistance (at SELLER's expense) for the defense of same. 2. BUYER shall defend and hold SELLER harmless from any claim made against SELLER or its suppliers that the manufacture or sale of goods supplied constitutes infringement of any United States patent, if such goods were manufactured pursuant to BUYER's designs specifications, processes, and/or formulas, and were not normally offered for sale by SELLER, provided SELLER promptly notifies BUYER in writing of the claim and gives BUYER full authority, information, and assistance (at BUYER's expense) for the defense of same. 3. The foregoing constitutes the parties entire liability for claims or actions based on patent infringement.

J. WAIVER Neither party shall be deemed to have waived any of its rights, powers or remedies, under this Agreement, or at law or in equity, unless such waiver is in writing and is executed by it. No delay or omission by either party in exercising any right, power, or remedy, shall operate as a waiver thereof or of any other right, power, or remedy. No waiver by either party of any default shall operate as a waiver of any other default, or of the same default on another occasion.

K. CHOICE OF LAW This agreement shall be governed by and construed in accordance with the laws of the State of California in all respects.

L. ASSIGNABILITY BUYER may not assign this Agreement with SELLER's prior written consent.

EXTRUSION INSPECTION SHEET

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		SIDE A		SIDE B		Measurment unit Inches		Symbol "		ULTRA SONIC MEASURMENTS					
TUBE #	TOTAL LENGTH	DIA		DIA		INSIDE DIA	wall thickness measured w/vern	Strightness at 12" in middle	Rockwell Reading	LOCATION on tube	R1	R2	R3	R4	
		R1	R2	R1	R2										
DWG									N/A	Middle	N/A				
1	106.125	3.223	3.225	3.221	3.224	2.262	.473	.430		N/A	Middle	.479	.481	.482	.480
2	106.06	3.226	3.223	3.220	3.230	2.260	.475	.430		N/A	Middle	.483	.482	.483	.482
3	106.125	3.225	3.223	3.216	3.221	2.262	.477	.430		N/A	Middle	.479	.478	.478	.478
4	106.06	3.226	3.223	3.212	3.217	2.269	.477	.430		N/A	Middle	.481	.479	.479	.479
5	106.06	3.223	3.225	3.229	3.229	2.269	.477	.473		N/A	Middle	.478	.481	.480	.479
6	106.125	3.216	3.219	3.219	3.222	2.270	.476	.473		N/A	Middle	.477	.478	.478	.479
7										N/A	Middle				
8										N/A	Middle				
9										N/A	Middle				
10										N/A	Middle				
11										N/A	Middle				
12										N/A	Middle				
13										N/A	Middle				
14										N/A	Middle				
15										N/A	Middle				
16										N/A	Middle				
PART #		P/O#				BATCH #				Notes:					

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